Work Order ID 121802

121802

Wednesday, July 02, 2014 3:35:06 PM

Item ID: D4008-11 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Hinge Half

Start Date: 7/02/14 **Start Qty:** 12.00 *12*

Required Date: 7/02/14 **Req'd Qty:** 12.00 *12*

Reference:

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** MLS **Date:** 14-07-03 **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4008 / D									
100		0.00							
100						12	0		
Small Fab	**Memo**	0.00							14.07.15
Small Fab	1- Cut Hinge as per Dwg keep 2nd half for D4008-5								
	2- DRILL HOLES AS PER DWG								PTO →
	3- Deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
110						VD	14.07.15		
QC	**Memo**	0.00							
Quality Control									

DQA: AwA Date: 14/08/01

QA Closed: [illegible] Date: 14/7/18

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

Work Order update only ☐

Work Order: 121802

Part No. D4008-11

NCR No. 14-4049

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐	14.07.15	100	1	holes were drill off center.	DAS 16 9-89	scrap 1 part no replace	[illegible] 14.07.15	DAS 9 9-89 14.07.15	DAS 16 9-89
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐				Rc. make jig to locate hole and drill / Lock & tooly.	QX2042 14/07/15				QX2043 14/07/15
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐						$ 293			

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Work Order ID 121802

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QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location ~~[illegible]~~	0.00							
120 Packaging	Memo G-A	0.00				10	0		14.07.15
Packaging									
130	QC21- Final Inspection - Work Order Release	0.00							
130 QC	Memo	0.00				MLJ 14-07-16			
Quality Control									

14-7-16

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Heat Treat
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☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

Wednesday, July 02, 2014 3:35:03 PM

Work Order ID: 121802

121802

Parent Item: D4008-11

D4008-11

Parent Item Name: Hinge Half

Start Date: 7/02/14 **Required Date:** 7/02/14

Start Qty: 12.00 **Required Qty:** 12.00

Comments: IPP REV:A NEW ISSUE 10-04-06 JLM VERIFIED BY:EC IPP Rev:B 10.05.03 as per ECN10-562 DD verified by:EC IPP REV:C 12.03.07 AS PER DWG REV.C DD VERF:EC IPP REV:D 14.06.12 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS20257-3-7200		Purchased	No			100	f	61.6420	0.4	5.052631			
MS20257-3-7200									**	14.07.15			
PIANO HINGE													

Location	Loc Qty	Loc Code	
ST209a 128635	61.642		1
m127172	12.6		
m127393	9.442		
m128401	4		
m128813	2.6		2.1
m128923	33		2.

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

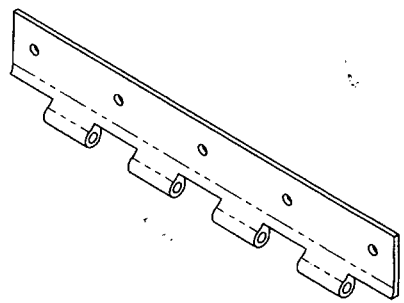
Landing Gear

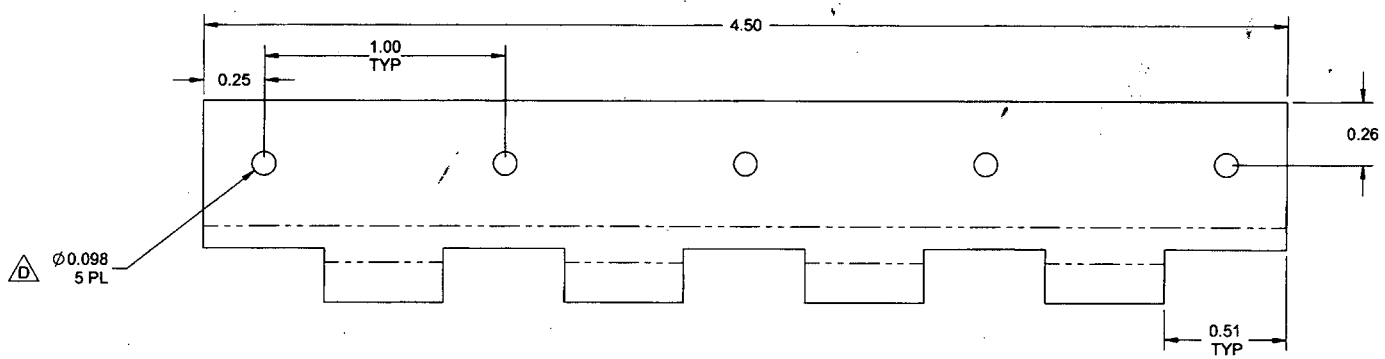
☐ Bending
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☐ Heat Treat
☐ Inspection Strip in Tube
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☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 121802 MJ
140775





D **D4008-11 TANK HINGE HALF**

RELEASED
2014 -06- 11

NOTES: D
1) MATERIAL: MADE FROM MS20001-4 HINGE OR MS20257-3 HINGE
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: STOCK AS D4008-11
7) WEIGHT: 0.01 lbs

APPROVED			
DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AP	DRAWING NO. D4008	REV. D
MFG. APPR.	JLM		SHEET 10 OF 10
APPROVED	MP	TITLE SPLASH GUARD	SCALE NTS
DE APPR.	DS		
DATE	14.05.13		

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DART AEROSPACE LTD

Description: D 4008-11 Work Order: 121802

Inspection Drawing: D 4008 Rev: D Part Number: 4008-11

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.098	30	0.099	✓		Caliper	
1.00	30	1.00	✓		Caliper	
4.50	30	4.502	✓		Caliper	
0.26	30	0.26	✓		Caliper	

DAS

Measured by: DAS 19 9-89	Checked By: 9 9-89	QC inspector:	Engineering Approval (*if necessary*)
Date 14.07.15	Date 14-07-15	Date 14/07/16	Date